

Work Order ID 140322

140322

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Monday, December 21, 2015 11:53:56 AM

Item ID: D5272-3 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Tube
 Start Date: 12/21/2015 Start Qty: 22.00 *22* 18
 Required Date: 12/21/2015 Req'd Qty: 22.00 *22*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: H Date: 15-12-23 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5272	A

110

0.01

110

Small Fab

Memo

0.00

Small Fab

1- CUT BLANK at 16.00"

2- BEND AS PER DWG WITH MANUAL BENDER AND USE DPT0177 AS A TEMPLATE. SCIBE ENDS FROM THE EDGE OF TEMPLATE AND CUT TO SIZE.

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

SCRAP

DQA:

Date: 16/02/02



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/02/01

Work Order update only ☐

Work Order: 140322		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. D5272-3		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. 16-5344		Scrap ☒		Machining ☐		Small Fab ☒		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date: 16-01-19		Step #: 110		QTY Effective: 13				MRB (QSI042) Approval DAS 9 9-89 16-01-19			
Description Work Order Deviation				Disposition				Completed By			
excessive crushing was found on D5272-83				Scrap & destroy no replace				JAN 19 2016			
P.C. tooling. not properly identify. employee not familiar with tooling.				scrib to orientation of tooling				Lead hand / Supervisor Approval Verification DAS 30 9-89 JAN 19 2016			
								QC / QA Coordinator DAS Approval 9 9-89 16-01-19			
Root Cause				FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☒	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☒	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐										
Misidentified ☐	Past Due ☐	OTHER :									

140322

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/21/2015 **Start Qty:** 22.00

22

Cust Item ID:**Required Date:** 12/21/2015 **Req'd Qty:** 22.00

??

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Outsource process-Anodize per QSI017 4.1.10.1

1.20

130

Outsource4

Memo

0.00

Outsource process - Anodize

ISSUE P/O TO ATG: _____

ANODIZE BLACK AS PER DWG AND MIL SPEC

C OF C IS REQUIRED

140

Receive & Inspect for Damage & Mat'l Certs

0.00

140

Packaging

Memo

0.00

Packaging

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Work Order ID 140322

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Item ID: D5272-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube
 Start Date: 12/21/2015 Start Qty: 22.00 ***??*** Cust Item ID:
 Required Date: 12/21/2015 Req'd Qty: 22.00 ***??*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							
Packaging	***GA***								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MCS JAN 19 2016
 Ø

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

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Work Order ID: 140322

140322

Parent Item: D5272-3

D5272-3

Parent Item Name: Aft Tube

Start Date: 12/21/2015

Required Date: 12/21/2015

Start Qty: 22.00

Required Qty: 22.00

Comments: IPP REV:A 15.07.09 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.500W.125		Purchased	No				f	51.0940		30.8			

M6061T6T1 500W 125

**

6061T6 RD TUBE 1.50 X .125W

Location

Loc Qty

Loc Code

MAT016

51.094

104025

10

123289

0.2098

m128118

4.8842

m133700

36

30.8

DQA: _____ Date: _____

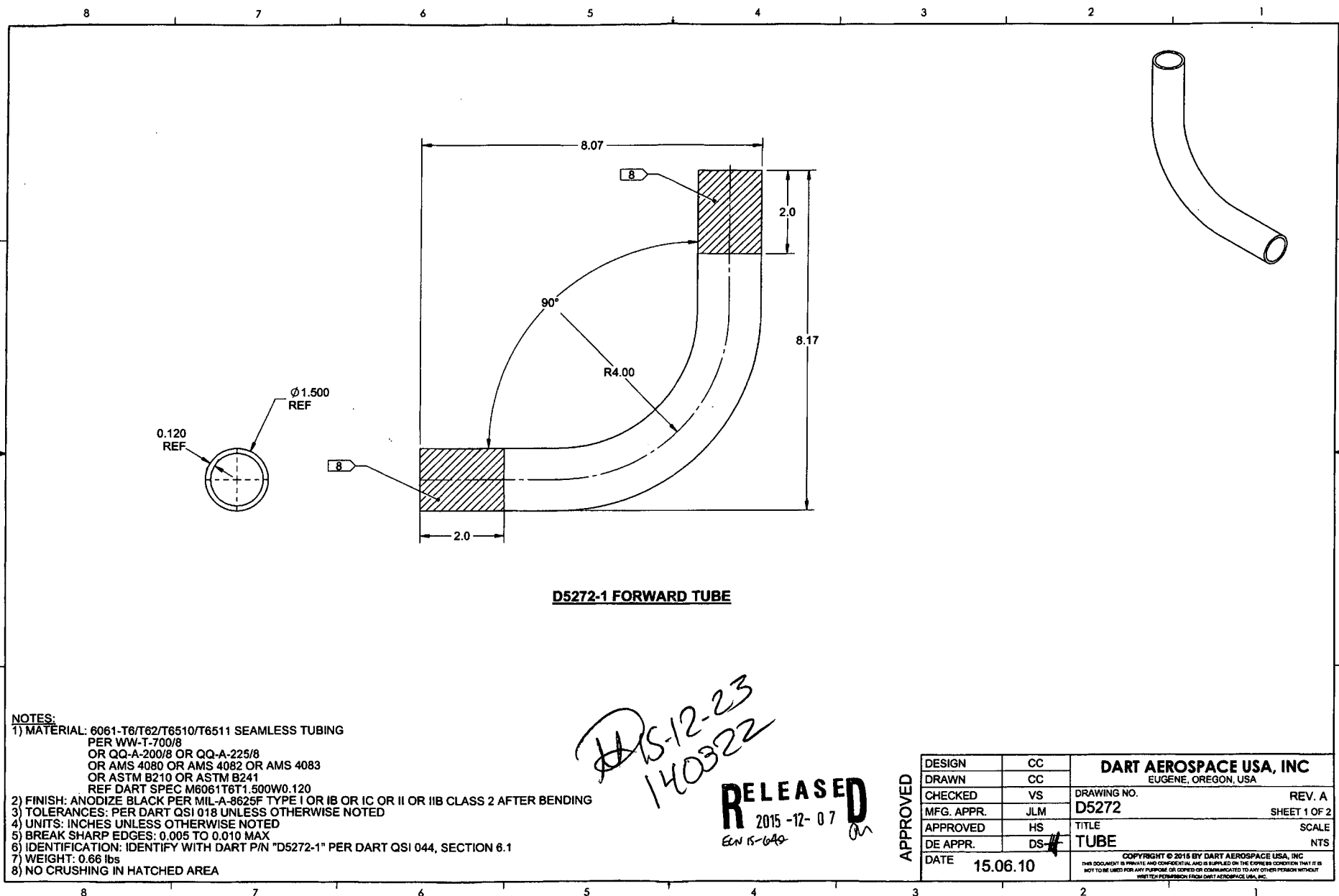


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							



NOTES:

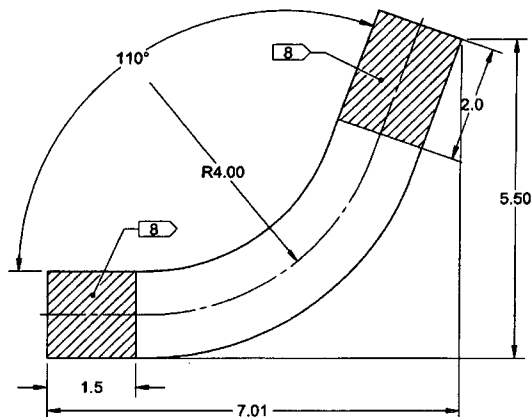
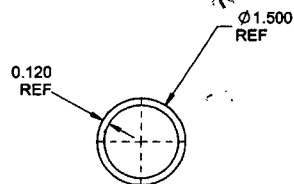
- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING
PER WW-T-700/8
OR QQ-A-200/8 OR QQ-A-225/8
OR AMS 4080 OR AMS 4082 OR AMS 4083
OR ASTM B210 OR ASTM B241
REF DART SPEC M6061T6T1.500W0.120
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER BENDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5272-1" PER DART QSI 044, SECTION 6.1
- 7) WEIGHT: 0.66 lbs
- 8) NO CRUSHING IN HATCHED AREA

Handwritten: 15-12-23
140322

RELEASED
2015-12-07
ECN 15-649

APPROVED

DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWN	CC		
CHECKED	VS	DRAWING NO. D5272	REV. A
MFG. APPR.	JLM	TITLE	SHEET 1 OF 2
APPROVED	HS	SCALE	NTS
DE APPR.	DS	TUBE	
DATE	15.06.10	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D5272-3 AFT TUBE

NOTES:

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING
PER WW-T-700/8
OR QQ-A-200/8 OR QQ-A-225/8
OR AMS 4080 OR AMS 4082 OR AMS 4083
OR ASTM B210 OR ASTM B241
REF DART SPEC M6061T6T1.500W0.120
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER BENDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5272-3" PER DART QSI 044, SECTION 6.1
- 7) WEIGHT: 0.46 lbs
- 8) NO CRUSHING IN HATCHED AREA

RELEASED
2015-12-07

APPROVED

DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWN	CC		
CHECKED	VS	DRAWING NO. D5272	REV. A
MFG. APPR.	JLM		SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TUBE	NTS
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